



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2946-041
Job Sheet 175212



Part No: D2946-041

Job Qty: 1 ea

Part Name: Step (AS350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/29/18

Job Tracking No:

Due Date: 4/13/18

Created By: Linda Lacelle

Type: SOLD

Description:

Ship Via:

Rev. B *Mar. 04.20*

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea		4/12/18	0.00	0.00	Start Up Large Fab-7		<i>DC 2018-04-03</i>
110	Large Fab	1 pcs		4/12/18	0.00	0.70	Large Fab 8		<i>DC 2018-04-03</i>
120	QC	1 pcs		4/12/18	0.00	0.00	QC5		<i>CPL</i>
130	Large Fab	1 pcs		4/12/18	0.00	0.70	Large Fab 2		<i>SL</i>
135	QC	1 pcs		4/12/18	0.00	0.00	QC9		<i>CPL</i>
140	QC	1 pcs		4/12/18	0.00	0.00	QC5		<i>CPL</i>
145	HandFinish	1 pcs		4/12/18	0.00	0.17	HandFinish1		<i>SA 18-04-06</i>
155	QC	1 pcs		4/12/18	0.00	0.00	QC7-5		<i>CPL</i>
180	Large Fab	1 pcs		4/12/18	0.00	0.70	Large Fab 2		<i>SL</i>
190	QC	1 pcs		4/12/18	0.00	0.00	QC9		<i>CPL</i>
200	QC	1 pcs		4/12/18	0.00	0.00	QC5		<i>CPL</i>
210	HandFinish	1 pcs		4/12/18	0.00	0.15	HandFinish1		<i>SA 18-04-09</i>
220	Powdercoat	1 pcs		4/12/18	0.00	0.10	Powdercoat1		<i>BR 18-4-10</i>
230	HandFinish	1 pcs		4/13/18	0.00	0.15	HandFinish3		<i>BEBAS-04-11</i>
240	QC	1 pcs		4/13/18	0.00	0.00	QC3		<i>11 APR 12 2018</i>
270	Packaging	1 pcs		4/13/18	0.00	0.00	Packaging3-1		<i>DA9-89</i>
280	QC21-FG	1 Ea		4/13/18	0.00	0.00	QC21		<i>21 APR 27 2018</i>

Part Op 110 - 1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946 2-Deburr **Ensure that 57.09" minimum extrusion is
Descriptions: kept and identify to be used for D350-591-215/-216.**

130 - 1-Deburr and Bevel ends for welding 2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946
A/R Aluminum Rod *M13873* 3-Grind End Cap welds flush

180 - Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush. A/R AL ROD
BATCH:

220 - START TIME: *11:50* OVEN TEMPERATURE: *320°* FINISH TIME: *1220*

230 - wing work M138761

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	.5000 Ea (.5 ea)	100-Start up Operation	<i>S057851</i>
D2734	Step End Plate	2 Ea (2 ea)	130-Large Fab	<i>S012001</i>
D2944	Step Mounting Plate	2 Ea (2 ea)	130-Large Fab	<i>1647316</i>

S057851x1

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Start up Operation	D2622-120C	1	216	0	
130-Large Fab	D2734	2	19	0	
	D2944	2	16	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Mounting Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
2	Step Mounting Plate	0.559Inches ± 0.010	0.569 0.549		
3	Step Mounting Plate	3.040Inches ± 0.030	3.070 3.010		
4	Step Mounting Plate	1.950Inches ± 0.030	1.980 1.920		
5	Step Mounting Plate	0.852Inches ± 0.010	0.862 0.842		
6	Step Mounting Plate	2.715Inches ± 0.001	2.716 2.714		
7	Step Mounting Plate	3.400Inches ± 0.030	3.430 3.370		

Plex 3/29/18 9:50 AM dart.lacelle.linda



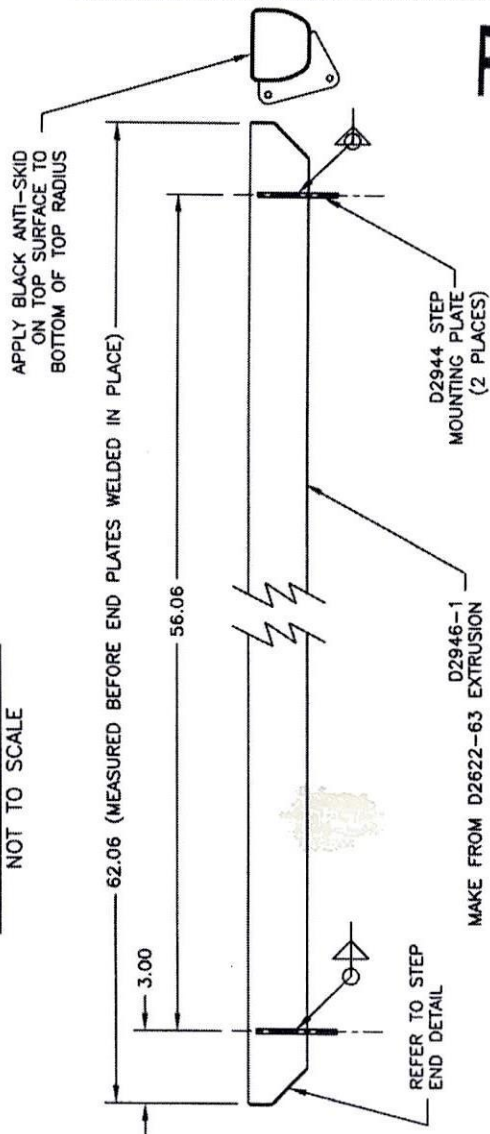
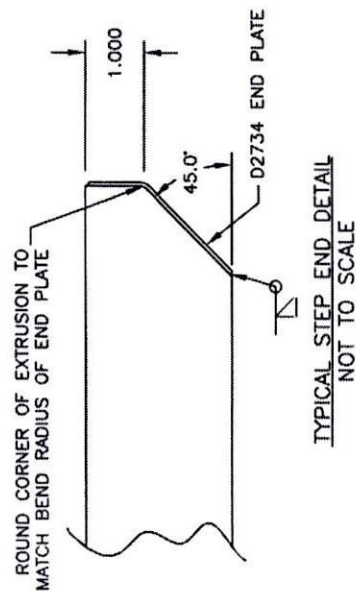
DESIGN	DRAWN BY	DART AEROSPACE LTD	
CP	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2946	SHEET 1 OF 1
DATE		TITLE	SCALE
05.11.14		STEP ASSEMBLY	1:6
A	99.12.13	NEW ISSUE	
B	05.11.14	UPDATE FINISHING NOTE	

D2946 STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2946	Step Assembly	X
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

*not per drawing

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



RELEASED
05.11.28

D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Container No: S057851



Part: D2946-041

Job No: 175212

Serial No/Batch: S057851

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/03/18

Master Unit 002189



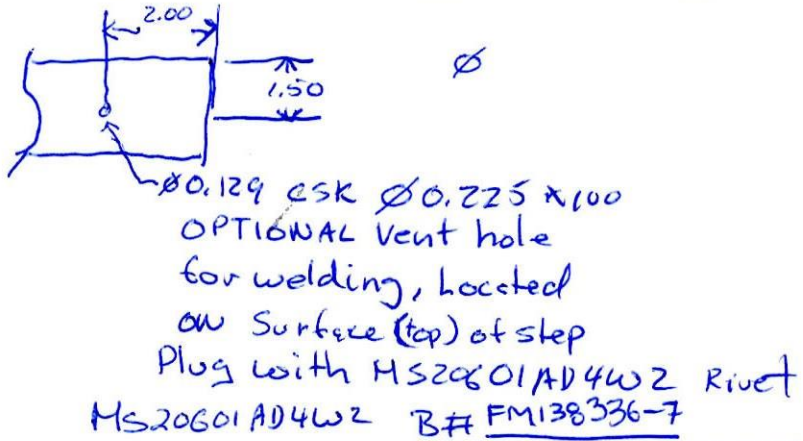
Job No 175212

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval DAS 12 9-89 18/4/4	
Description Work Order Deviation		Disposition		Completed By DAS 51 9-89 18/4/04	
		Acceptable. No effect on strength. Same process is done on similar steps.		Lead hand / Supervisor Approval Verification CPC 18/10/04	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					